



Dart Aerospace Ltd.
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Tel (613) 632-5200

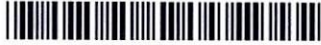
D3302-1
Job Sheet 179456



Part No: D3302-1

Job Qty: 4 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3302 REV B2 IPP Rev: A 04.09.02 New issue KJ/JLM IPP Rev: B Now on Waterjet 07-06-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/6/18	0.00	0.00	Start Up Waterjet		SC 18/06/24
100	Waterjet	4 pcs		7/6/18	0.00	0.30	Waterjet1		SC 18/06/24
110	QC	4 pcs		7/6/18	0.00	0.00	QC2 Waterjet-1		SC 18/06/24
120	QC	4 pcs		7/6/18	0.00	0.00	QC8-2		38
130	Small Fab	4 pcs		7/6/18	0.00	0.17	Small Fab-3		9-89
140	Brake NC	4 pcs		7/6/18	0.00	0.59	Brake NC 2		DAS
150	QC	4 pcs		7/6/18	0.00	0.00	QC5		38
160	HandFinish	4 pcs		7/6/18	0.00	0.31	HandFinish1		3A 18-07-09
170	QC	4 pcs		7/6/18	0.00	0.00	QC3		38
180	Packaging	4 pcs		7/6/18	0.00	0.00	Packaging3-1		38
190	QC21-SA	4 Ea		7/6/18	0.00	0.00	QC21		38

Part Op 100 - 1-Cut as per Dwg D3302 Dwg Rev: B2 Prog Rev: B2 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Deburr break all unmarked sharp edges 0.005 to 0.010

140 - Form as per Dwg D3302

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	3.0840 sf (.771 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	3	318	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																	
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																															
Description Work Order Deviation			Disposition																																																																																
			Completed By _____ / Supervisor Verification _____ Coordinator approval _____																																																																																
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			DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																																
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Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
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